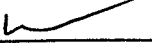


Date: Thursday, 1/11/2007 10:19:18 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TUBE ASSEMBLY
Job Number : 30164	
Estimate Number : 12625	
P.O. Number : N/A	Part Number : D2127251903
This Issue : 1/11/2007 S.O. No. : N/A	Drawing Number : D212-725-1 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : 1/4/2007 Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 1/11/2007 Qty: 5 Um: Each
Checked & Approved By : _____	
Comment : Est Rev:A New Issue 07-01-04 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TR0625W035	304 RD Tube .625 x .035W
-----	----------------	--------------------------



Comment: Qty.: 5.7750 f(s)/Unit Total : 28.8750 f(s)

304 RD Tube .625 x .035W

Batch: M102958

SRB 07-01-11 ⑤

2.0	AN81810J	nut
-----	----------	-----



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

nut

Batch: M102850

FF 07-01-11

3.0	MS2081910J	sleeve
-----	------------	--------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 10.0000 Each(s)

sleeve

Batch: M102850

FF 07-01-11

4.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

SMALL & MEDIUM FAB RESOURCE 1

1-Form tube as per Dwg D212-725-1& Template DT8906.

2- Flare tube @ 37 deg ,Install sleeve & Nuts as per Dwg D212-725-1.

FF 07-01-11

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TUBE ASSEMBLY

Job Number: 30164

Part Number: D2127251903

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
INSPECT WORK TO CURRENT STEP

07/01/15 (5)

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs
PACKAGING RESOURCE #1
Identify and Stock
Location: _____

07-06-15 5

7.0

QC21

FINAL INSPECTION/W/O RELEASE



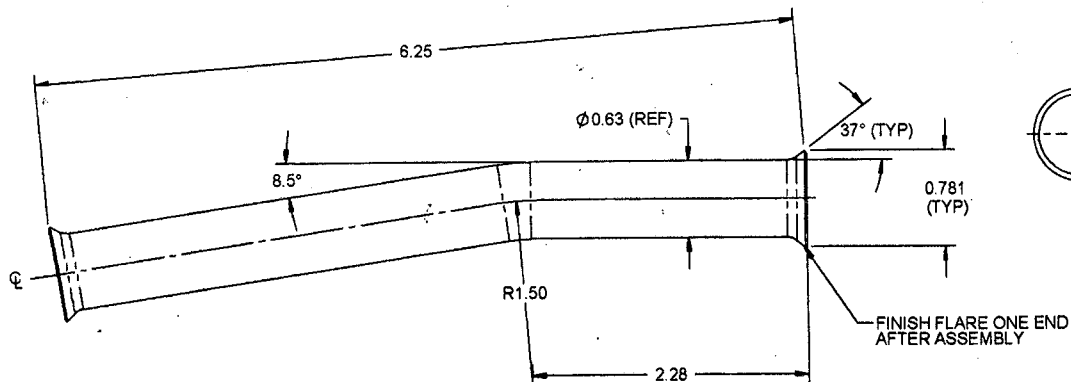
Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs
FINAL INSPECTION/W/O RELEASE

07/01/15 (5)

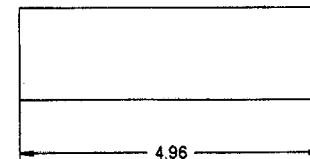
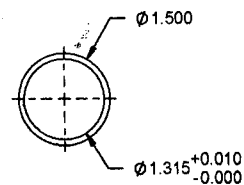
Job Completion



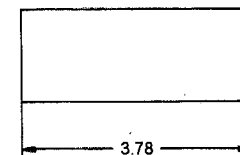
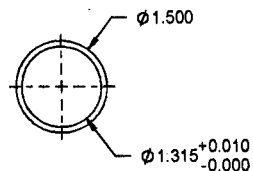
07-06-15



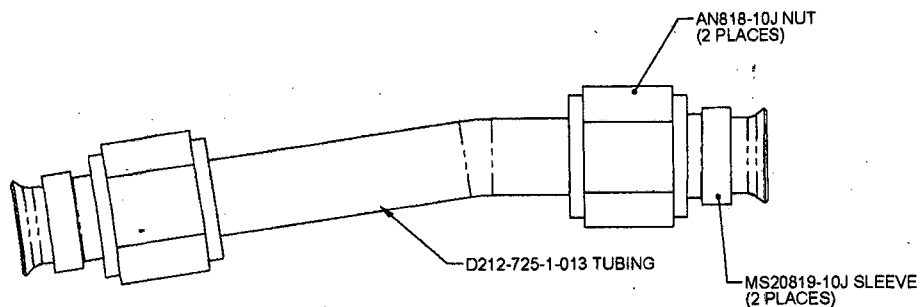
D212-725-1-013 TUBING
MANUFACTURE PER TEMPLATE DT8906



D212-725-1-025 SPACER
SCALE 1:2



D212-725-1-027 SPACER
SCALE 1:2



D212-725-1-903 TUBE ASSEMBLY

D212-725-1-025/-027 NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM (REF. DART SPEC. M6061TX.XXXW.XXX OR M6061T6R)
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

D212-725-1-013 NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBING 0.625 O.D. x 0.035 WALL (REF. DART SPEC. M304TR0.625W0.035)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

DESIGN	DRAWN BY	DART AEROSPACE LTD	
DC	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
DS		D212-725-1	SHEET 6 OF 37
DATE		TITLE	SCALE
06.12.08		212S DETAIL PARTS	1:1
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